

Date: Wednesday, 29/10/2008 8:10:53 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ADJUSTABLE ATTACHMENT ARM ASSY
Job Number	: 43054		
Estimate Number	: 13479		
P.O. Number	:	Part Number	: PB674300159
This Issue	: 29/10/2008 S.O. No. :	Drawing Number	: B6743001 P.14
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 41383	Material	:
Written By	:	Due Date	: 05/11/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>MF 08-10-29</u>		
Comment	: Est Rev:A 08-07-18 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001113	Square Tubing
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✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Tubing

batch: B41477 (2x) MF 08-11-04

2.0	PB6743001119	End Cap Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

End Cap Clevis

batch: B 22991 x1, 40016 x1 (2x) MF 08-11-04

3.0	PB6743001117	Hook Plate
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✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Hook Plate

batch: 41865 (2x) MF 08-11-04

4.0	PB6743001115	Tube End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube End Plate

batch: 40014 (2x) MF 08-11-04

5.0	PB6743001271	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) ✓

Doubler

batch: 41493 (2x) MF 08-11-04

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M6061T6T1750W065

6061T6 RDTUBE 1.750 X 0.65W



Comment: Qty.: 0.1575 f(s)/Unit Total: 0.3150 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: M 18489

SP 08.11.04

(2X)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1- to make -105 take M6061T6 tube and fabricate to fit contour of cut SP

2- Weld -105 to -113 as per dwg and grind weld flush SP

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001 SP

4- pick two -271 and weld one on each side of tubing but only one need to be trim to fit on -113 as per dwg

PB67-43001

SP 08.11.05

(2X)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Cpl 08.11.05 BE

(2X)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/05 (2)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FZ 08/11/07

(2)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 102316

(2X)

1- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30
320 OF
11:00

M 08/11/10

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08 - 11 - 11

(2X)

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Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001267

PB67-43001-267



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

PB67-43001-267

batch: 41499

14.0

PB6743001121

Square Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Square Sleeve

batch: 41866

15.0

BSP43

RIVET



Comment: Qty.: ~~4.0000~~ Each(s)/Unit Total: ~~12.0000~~ Each(s)

RIVET

batch: M109119

16.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

PIN, QUICK RELEASE

batch: M18119

17.0

30345T21

LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

LANYARD

batch: 17828

18.0

MS27039122

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

SCREW

batch: 18057

19.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

batch: M109031

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Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

NAS1149F0332P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

batch: 18057

Re 8/4/10

21.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- take -267 and transfer drill holes in -113 as per dwg PB67-43001

2- deburr and rivet -267 to -113 as per dwg

3- assemble rest of parts as per dwg PB67-43001

SAN 08-11-17

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/18

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST446B

AS 08/11/20

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/21

Job Completion



MF 08-11-20

RELEASED
9-11-2

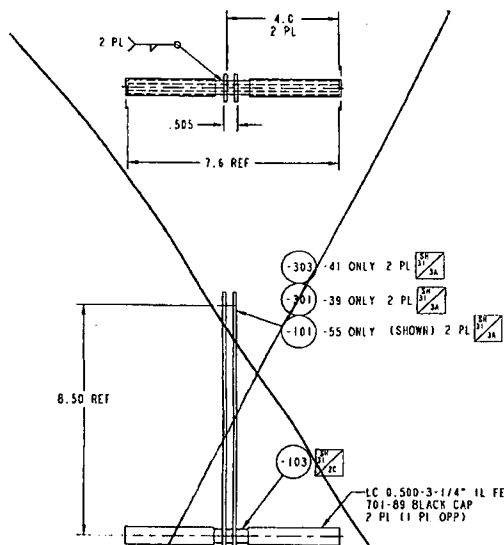
8 7 6 5 4 3 2 1

D

C

B

A

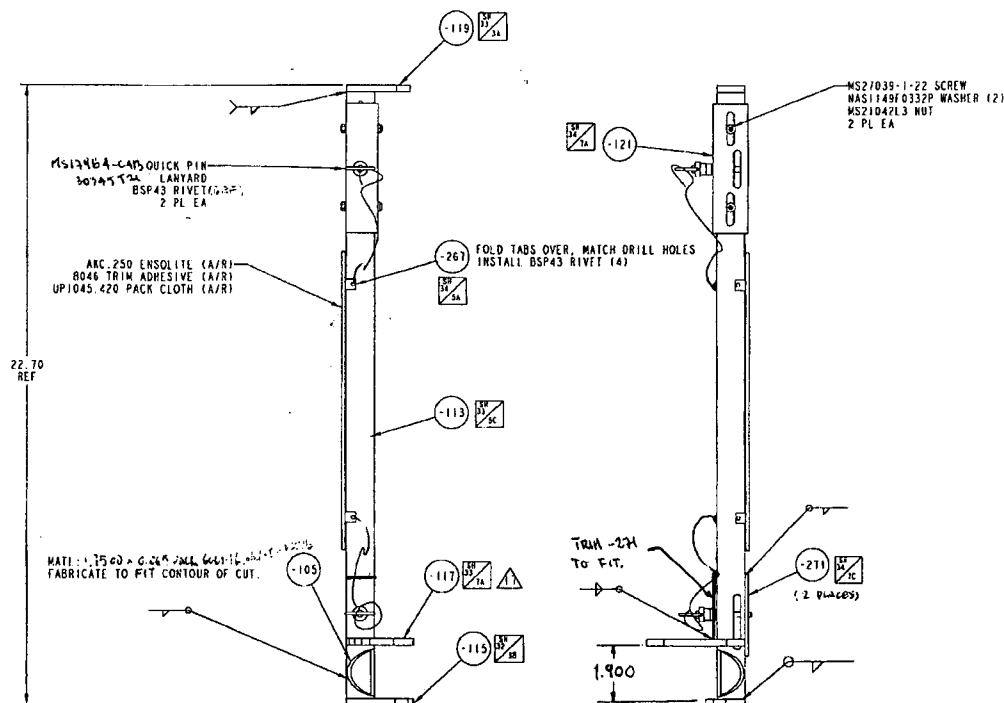


- ① -39 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
- ① -41 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
- ② -55 HANDLE AND LOCK-DOWN ASSEMBLY (SHOWN)

SCALE 0.500

SUPERCEDED BY

SUPERSEDED BY D3451-041/-043/-045/-047



- ① -59 ADJUSTABLE ATTACHMENT ARM ASSY

SCALE 0.500

#43054

PREMIER AVIATION, INC.			
2002 Aviation Parkway, Grand Prairie, Texas 75002			
DATE	CONF. IDENT. NO.	REV.	
01/05/81	B67-43001	81	
SCALE	WT.	SHEET	14 OF 45

ORIGINAL

8 7 6 5 4 3 2 1